

Work Order ID 78550

January-11-12 10:54:58 AM

78550

U/R

Page 1

Item ID: D412-742-013 Accept *N900040100* Setup Start *NS1*
 Revision ID: U/R OK 12.2.08 Stop *NS2*
 Item Name: Float Skidtube Installation
 Start Date: 11/01/2012 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 31/01/2012 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: M.C.J. Date: 12/01/11 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
DSI 9517	B
IIN D412-742	E

100 DOCUMENT CONTROL 0.00
 100
 DC Memo 0.00
 Document Control Photocopy bluefile and create labels per PPP D412-742-013 CHG007

110 Pick Kit 0.00
 110
 Packaging Memo 0.00
 Packaging

12 '02 - 22 (1)
 Form M5 12-2-9

6/4/10 (1)

1566E81

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 78550

January-11-12 10:54:58 AM

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Page 2

Item ID: D412-742-013 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: U/R Stop ***NS2***
 Item Name: Float Skidtube Installation
 Start Date: 11/01/2012 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 31/01/2012 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									
130		0.00							
130	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-742-013								
	Location: <u>73</u>								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

12 02 22 (1)

SP 12-02-22

M.L.J 12/02/23
 MF
 12-02-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 78550

78550

Parent Item: D412-742-013

D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 11/01/2012

Required Date: 31/01/2012

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev: A05.10.13 New Issue KJ/JLM
 IPP Rev: B 06-06-08 As per DSI9336 JLM IPP Rev: C 07-12-03 ECN 1072 DD verified by: JLM
 IPP Rev: D 08-09-08 ecn 08-510 DD verified by: EC
 IPP Rev: E 09-01-23 as per DSI9441 DD verified by: EC IPP Rev: F: add AN4C7A DD 10.01.13 verified by: EC IPP Rev: G 11.11.01 as per DSI9517 REV.B DD verified by: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D412-742-043

Manufactured No

110

Each

0.0000

1

D412-742-043

**

Replacement Float Skidtube

D2571

Manufactured No

110

Each

9.0000

1

D2571

**

Saddle, Fwd Out 205

Location

Loc Qty

Loc Code

ST425

-11

76438

1

ST433

20

77446

8

D2572

Manufactured No

110

Each

2.0000

1

D2572

**

Saddle, Fwd In 205

Location

Loc Qty

Loc Code

ST433

2

71107

2

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January-11-12 10:55:03 AM

Page 2

Work Order ID: 78550

78550

Parent Item: D412-742-013

D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 11/01/2012

Required Date: 31/01/2012

Start Qty: 1.00

Required Qty: 1.00

D2573

Manufactured No

110

Each

1.0000

1

1

D2573

Saddle, Aft Out 205

**

Location

Loc Qty

Loc Code

ST423

-12

ST434

13

77287

1

D2574

Manufactured No

110

Each

1.0000

1

1

D2574

Saddle, Aft In 205

**

Location

Loc Qty

Loc Code

ST434

1

77286

1

D2876

Manufactured No

110

Each

57.0000

2

2

D2876

Saddle Spacer

**

Location

Loc Qty

Loc Code

ST025

57

76949

57

D2877

Manufactured No

110

Each

57.0000

2

2

D2877

Saddle Spacer

**

Location

Loc Qty

Loc Code

ST020

57

73309

7

77052

50

236
78550
E sf

79923
E sf

2
E sf

76949
2
E sf

77052

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January-11-12 10:55:03 AM

Page 3

Work Order ID: 78550

78550

Parent Item: D412-742-013

D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 11/01/2012

Required Date: 31/01/2012

Start Qty: 1.00

Required Qty: 1.00

D3403-1
D3403-1
Bushing

Manufactured No 110 Each 40.0000 8 8

**

50208

[Handwritten signature]

Location Loc Qty Loc Code

ST041 40
70696 15
76213 25

D3403-5
D3403-5
Bushing

Manufactured No 110 Each 0.0000 8 8

**

B79740

[Handwritten signature]

D2747
D2747
Set Screw

Manufactured No 110 Each 166.0000 4 4

**

[Handwritten signature]

Location Loc Qty Loc Code

ST017 166
77484 166

D3533-1
D3533-1
Set Screw

Manufactured No 110 Each 54.0000 2 2

**

77484
2

[Handwritten signature]

Location Loc Qty Loc Code

ST054 54
73310 4
77611 50

77611

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 78550

78550

Parent Item: D412-742-013

D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 11/01/2012

Required Date: 31/01/2012

Start Qty: 1.00

Required Qty: 1.00

AN4C6A Purchased No 110 Each 364.0000 16 16
AN4C6A
 Bolt

Location	Loc Qty	Loc Code
FG	4	
103344	4	
ST356	360	
116704	8	
119328	152	119328
119749	200	

AN4C53A Purchased No 110 Each 21.0000 4 4
AN4C53A
 Bolt

Location	Loc Qty	Loc Code
ST361	21	
119688	1	
119861	20	119861

AN4C52A Purchased No 110 Each 87.0000 4 4
AN4C52A
 BOLT

Location	Loc Qty	Loc Code
ST361	87	
117688	7	
118451	30	118451
119641	50	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 78550

78550

Parent Item: D412-742-013

D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 11/01/2012

Required Date: 31/01/2012

Start Qty: 1.00

Required Qty: 1.00

AN6C12A

Purchased

No

110

Each

118.0000

8

8

**

AN6C12A

BOLT

Location

Loc Qty

Loc Code

ST341

118

119749

43

119862

75

D3672-3

Manufactured

No

110

Each

868.0000

32

**

D3672-3

Phenolic Washer

Location

Loc Qty

Loc Code

ST074

868

64176

180

73487

188

76278

500

AN960C416L NAS1149C04Y32R

Purchased

No

110

Each

0.0000

32

**

AN960C416I

WASHER

D3672-9

Manufactured

No

110

Each

184.0000

8

8

**

D3672-9

Phenolic Washer

Location

Loc Qty

Loc Code

ST074

184

35523

184

NAS1149C0632R

Purchased

No

110

Each

145.0000

8

8

**

NAS1149C0632R

WASHER

Location

Loc Qty

Loc Code

ST297

145

118006

45

119736

100

January-11-12 10:55:03 AM

Shop Packet Print

Page 5

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January-11-12 10:55:03 AM

Page 6

Work Order ID: 78550

78550

Parent Item: D412-742-013

D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 11/01/2012

Required Date: 31/01/2012

Start Qty: 1.00

Required Qty: 1.00

D3672-11
D3672-11
Phenolic Washer

Manufactured No

110 Each

551.0000 8 8

**

[Handwritten signature]

Location

Loc Qty

Loc Code

ST074

551

58046

51

77483

500

58046
77483

MS21043-4

Purchased No

110 Each

1,038.000 29 29

**

[Handwritten signature]

MS21043-4
Nut

Location

Loc Qty

Loc Code

FG

40

104603

40

ST300

470

118686

470

ST301

528

119309

32

119546

496

118686

D3403-3

Manufactured No

110 Each

28.0000 8 8

**

80209

[Handwritten signature]

D3403-3
Bushing

Location

Loc Qty

Loc Code

ST042

28

76215

28

D3405-041

Manufactured No

110 Each

8.0000 1 1

**

77686

[Handwritten signature]

D3405-041
Lug Assembly

Location

Loc Qty

Loc Code

ST478

8

62227

2

77000

6

January-11-12 10:55:03 AM

Shop Packet Print

Page 6

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 7

Work Order ID: 78550

78550

Parent Item: D412-742-013

D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 11/01/2012

Required Date: 31/01/2012

Start Qty: 1.00

Required Qty: 1.00

D3405-043

Manufactured No

110 Each

12.0000 1 1

D3405-043

Lug Assembly

**

77688

[Signature]

Location

Loc Qty

Loc Code

ST423

2

65703

2

ST474

10

76999

10

AN4C7A

Purchased No

110 Each

279.0000 4 4

AN4C7A

Bolt

**

[Signature]

Location

Loc Qty

Loc Code

ST356

279

109147

279

D3407-041

Manufactured No

110 Each

0.0000 1 1

D3407-041

Tow Ring

**

109147

76999

[Signature]

D3417-3

Manufactured No

110 Each

48.0000 2 2

D3417-3

Washer

**

[Signature]

Location

Loc Qty

Loc Code

FG

9

33519

9

ST042

39

53182

15

66847

24

53182

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 78550

78550

Parent Item: D412-742-013

D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 11/01/2012

Required Date: 31/01/2012

Start Qty: 1.00

Required Qty: 1.00

D3456-1

Manufactured No

110 Each

75.0000

1 1

D3456-1

Washer

**

Location

Loc Qty

Loc Code

FG

7

25701

7

ST034

50

77486

50

ST044

18

66848

3

71165

2

73493

13

AN3C37A

Purchased No

110 Each

128.0000

1 1

AN3C37A

BOLT

**

Location

Loc Qty

Loc Code

ST354

128

116874

11

117010

2

118709

50

119324

25

119531

40

AN3C40A

Purchased No

110 Each

67.0000

1 1

AN3C40A

BOLT

**

Location

Loc Qty

Loc Code

ST354

67

112454

17

114442

50

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 78550

78550

Parent Item: D412-742-013

D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 11/01/2012

Required Date: 31/01/2012

Start Qty: 1.00

Required Qty: 1.00

AN3C41A

Purchased

No

110

Each

162.0000

1

1

AN3C41A

BOLT

**

Location

Loc Qty

Loc Code

FG

4

103324

4

ST354

158

119324

48

119530

60

119673

50

119324

AN3C42A

Purchased

No

110

Each

49.0000

1

1

AN3C42A

BOLT

**

Location

Loc Qty

Loc Code

ST354

49

106176

1

117763

3

118131

20

119673

25

118131

AN3C43A

Purchased

No

110

Each

39.0000

4

4

AN3C43A

BOLT

**

Location

Loc Qty

Loc Code

ST354

39

114455

8

118387

6

119673

25

119673

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January-11-12 10:55:03 AM

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Work Order ID: 78550

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Parent Item: D412-742-013

D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 11/01/2012

Required Date: 31/01/2012

Start Qty: 1.00

Required Qty: 1.00

AN3C46A

Purchased

No

110

Each

87.0000

5

5

AN3C46A

BOLT

**

Location

Loc Qty

Loc Code

ST355

87

118758

17

119673

50

119861

20

119673

AN960C10L

NAS1149C0332
R

Purchased

No

110

Each

0.0000

26

26

***AN960C10I ***

washer

**

MS21043-3

Purchased

No

110

Each

1,273.000

13

13

MS21043-3

Nut

**

Location

Loc Qty

Loc Code

FG

72

103691

72

ST300

662

119901

662

ST301

539

118077

2

118614

441

118686

30

119758

66

119901

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

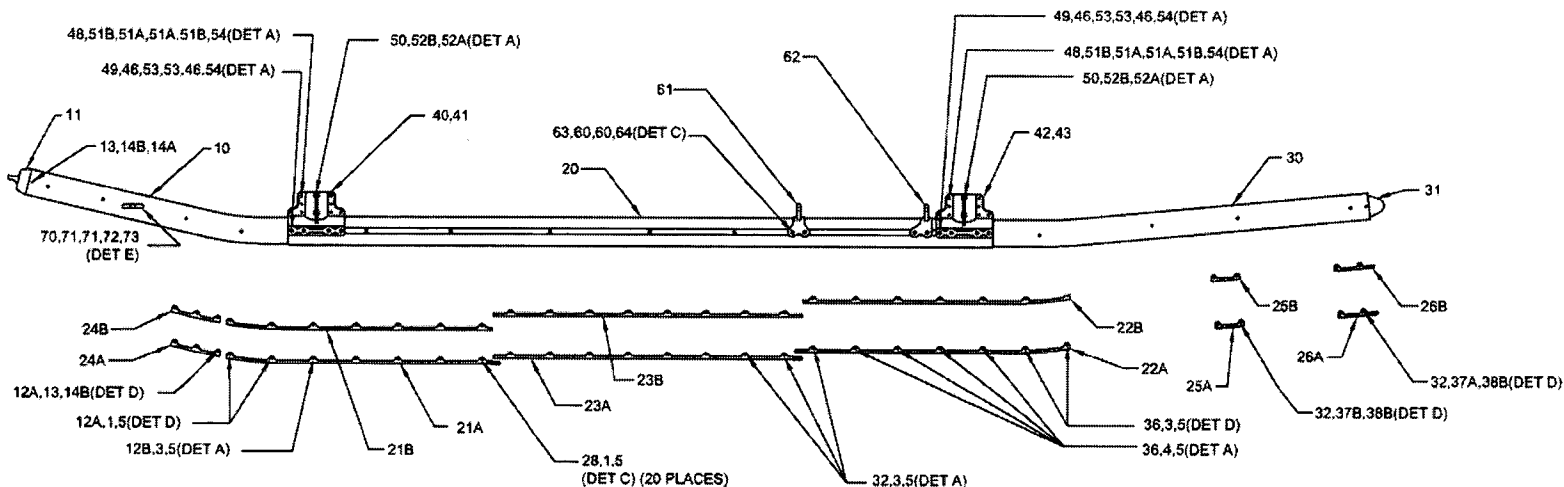
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
78550 H.C.J
12/01/11



**FIGURE 4 – D412-742-013 FLOAT SKIDTUBE INSTALLATION
(APICAL TRI-BAG COMPATIBLE)**

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Revision: **D**
Date: 07.10.04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

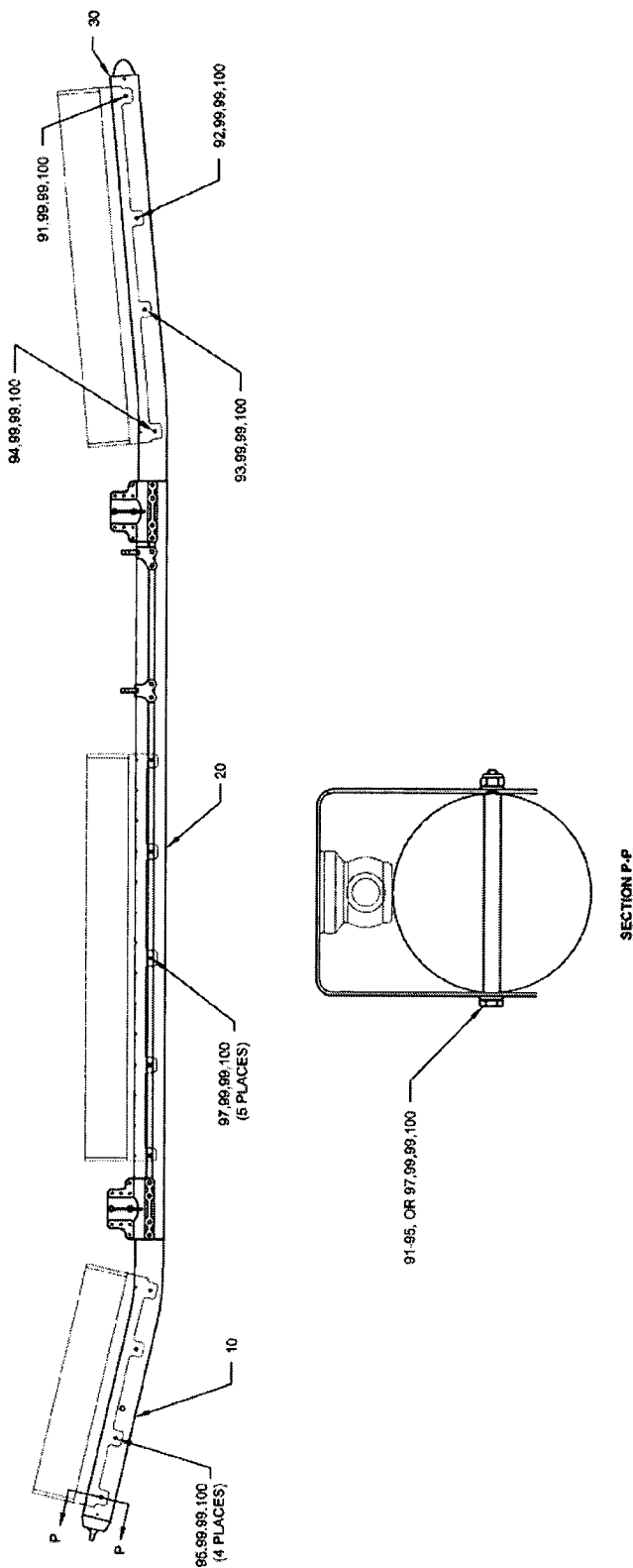
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

70550



**FIGURE 5 – D412-742-013 FLOAT BAG ATTACHMENT BOLTS AND LOCATIONS
(APICAL TRI-BAG COMPATIBLE)**

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Revision: **D**
Date: 07.10.04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

78550

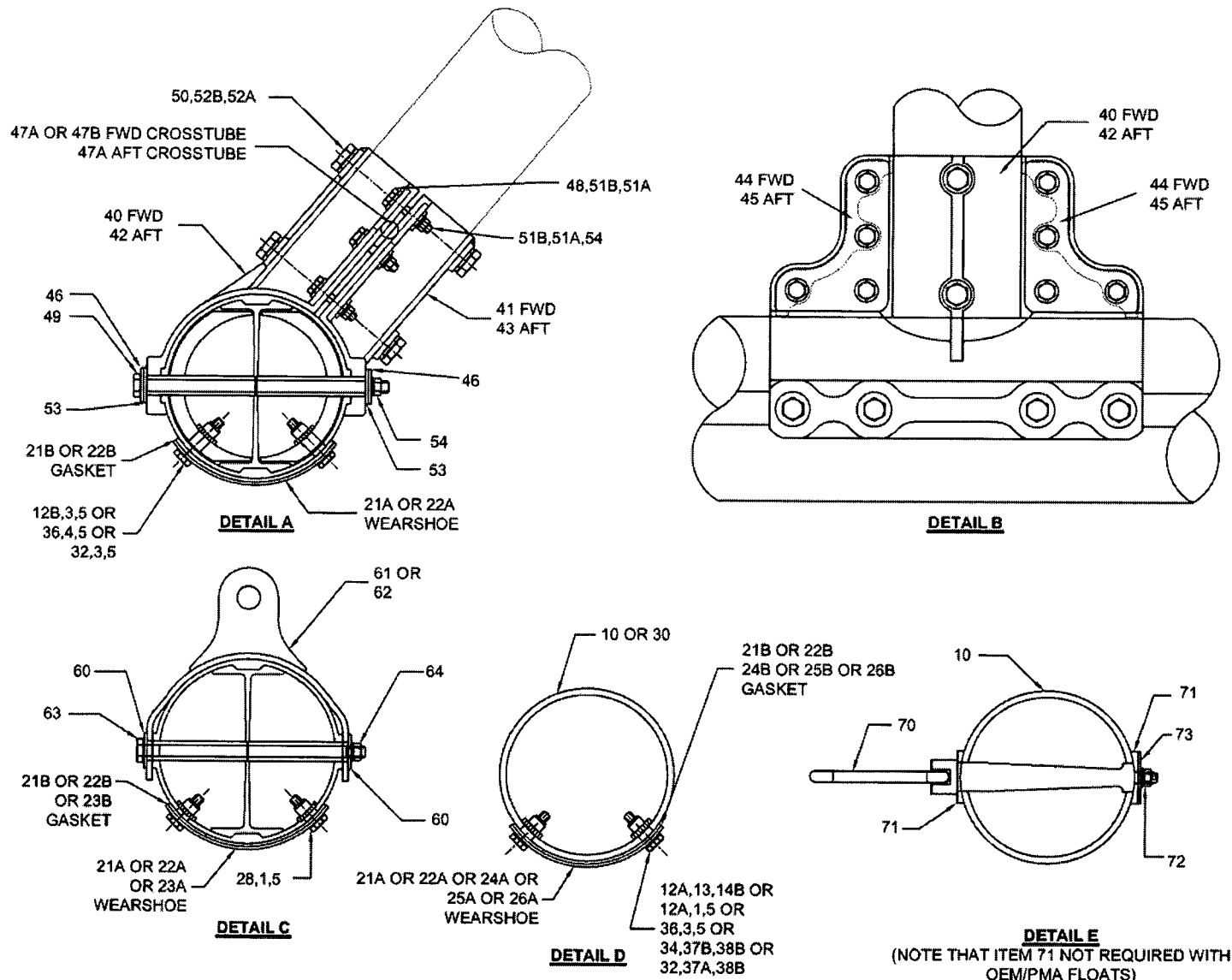


FIGURE 6 - D412-742-011/-013 DETAILS

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Revision: **D**

Date: 07.10.04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes, No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries